

Date: Thursday, 2/14/2008 11:01:38 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: JACK SADDLE
Job Number	: 37445		
Estimate Number	: 11177		
P.O. Number	:	Part Number	: D2281
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D2281 REV G
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: G
Previous Run	: 36824	Material	:
Written By	:	Due Date	: 3/20/2008 Qty: 100 Um: Each
Checked & Approved By	: <u>080214</u>		
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM Est: rev B 06.07.17 waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S14GA	304SS .080
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Comment: Qty.: 0.1313 sf(s)/Unit Total : 13.1250 sf(s)
304SS .080

batch: 107244 IB 8-2-26

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D2281

Dwg Rev: G IB 8-2-26
Prog Rev: G

(110)

2-Deburr if necessary IB 8-2-26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

080227 (110) counted

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: Deburr

N/A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 08/03/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 11:01:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 37445

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 08/03/07 (110)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(08/03/07) (110) counts

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

2/2/10 Sylvia (110)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(110)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/11

Job Completion



2008/3/10 (110)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37445
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.470	*			
4.114	+/-0.010	4.116	*			
2.933	+/-0.010	2.941	*			
1.535	+/-0.010	1.540	*			
0.354	+/-0.010	.354	*			
0.354	+/-0.010	.354	*			
0.604	+/-0.010	.604	*			
2.000	+/-0.010	2.000	*			
3.396	+/-0.010	3.396	*			
3.646	+/-0.010	3.646	*			
4.000	+/-0.010	4.005	*			
1.525	+/-0.010	1.530	*			
2.475	+/-0.010	2.479	*			
Ø0.323	+0.006/-0.001	.324	*			
0.080	+/-0.010	.075	*			

Measured by: RB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 8-2-26	Date: 06-02-27	Date:	N/A

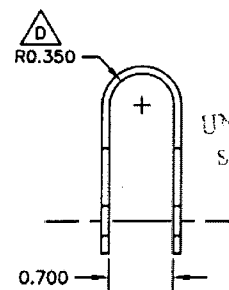
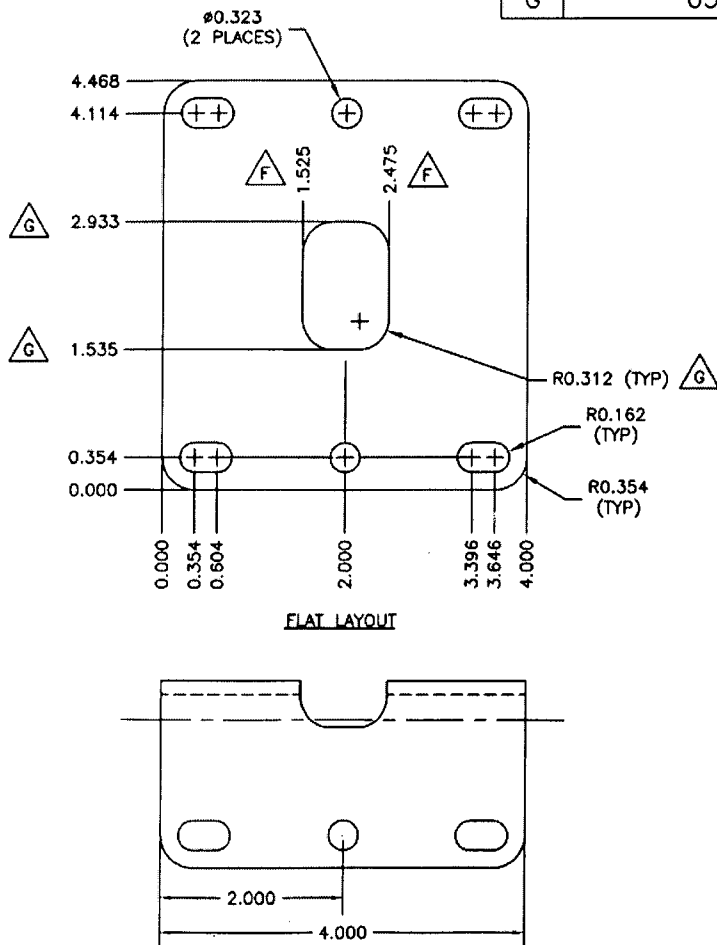
Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM [Signature]	[Signature]



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE	SCALE 1:2	
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED

05/08/11



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37445

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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